

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, September 24, 2010 3:28:22 PM

Page 2

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

**Insp.
Stamp**

0.00

Sidorovs

0.00

Quality Control

0.00

0.00

Memo

1- C'sink holes as per dwg
2- Forme D4108-5 as per dwg

0.00

0.00

Memo

Quality Control

8/10/12
Per Rev A

PTC

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4108-5 PAR #: PCR10-370 Fault Category: Eng-drawing NCR: Yes ☒ No ☐ DQA: [Signature] Date: 10/10/18
 Resolution: Doc. Revised Disposition: USE AS IS QA: N/C Closed: _____ Date: _____

NCR: <u>62303</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/10/18</u>	<u>100</u>	<u>Incorrect view on DWG.</u>	<u>[Signature]</u> <u>per Eng</u>	<u>update/change Dwg</u> <u>open a Per to correct</u> <u>Dwg. PCR10-370</u>	<u>[Signature]</u> <u>10/10/18</u>	<u>[Signature]</u> <u>10/10/18</u>	<u>[Signature]</u> <u>per Eng</u> <u>per Eng</u>	<u>[Signature]</u> <u>10/10/18</u>

NOTE: Date & initial all entries

Work Order ID 62303

Friday, September 24, 2010 3:28:22 PM



Page 3

Item ID: D4108-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Small Right Door Doubler

Start Date: 9/27/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
Description*David A.*Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *129*

0.00



Packaging

Memo

0.00

Packaging

*10.10.12**10/4/12 (6)*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10.10.18**10.10.19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 24, 2010 3:28:22 PM

Page 1

Work Order ID: 62303

Parent Item: D4108-5

Parent Item Name: Small Right Door Doubler



Start Date: 9/27/2010

Required Date: 10/4/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	153.2400	0.03154	0.0996	2		
304/316 Sheet .063												10-9-07	

Location

Loc Qty

Loc Code

MAT

146.7

111323

0

115688

146.7

MAT20

6.54

115440

6.54

115688

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 62303
Description: SMALL RIGHT DOOR DOOR LOCK		Part Number: D4108-5
Inspection Dwg: D4108-5 Rev: A		Page 1 of 1

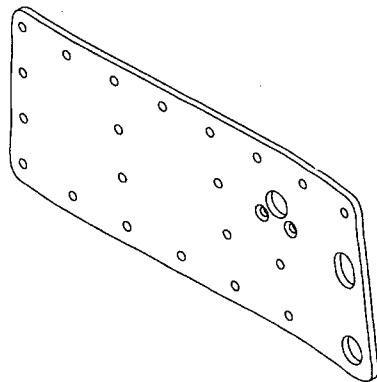
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

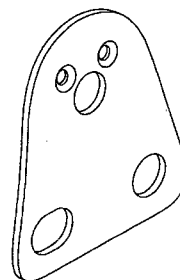
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .005 - .001	.130	✓		V B62	
Ø .375	+ .006 - .001	.375	✓		✓	
Ø .386	+ .006 - .001	.386	✓		✓	
.508	± .010	.508	✓		✓	
.254	± .010	.254	✓		✓	
.254	± .010	.254	✓		✓	
1.53	± .030	1.533	✓		✓	
.375	± .010	.374	✓		✓	
.40	± .030	.397	✓		✓	
.96	± .030	.96	✓		✓	
2.01	± .030	2.009	✓		✓	
.60	± .030	.601	✓		✓	
.490	± .010	.489	✓		✓	
.400	± .010	.401	✓		✓	
2.26	± .030	2.263	✓		✓	
.063	± .010	.060	✓		✓	

Measured by: RB	Audited by: D	Prototype Approval: N/A
Date: 10-9-87	Date: 10/9/87	Date: N/A

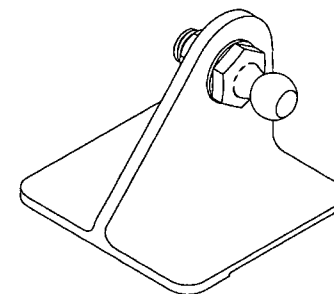
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



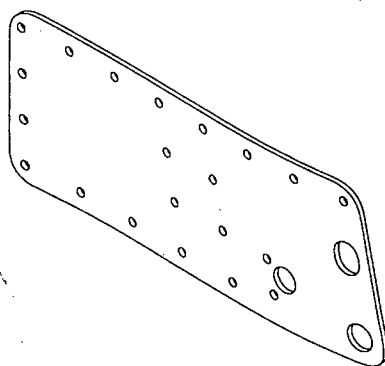
D4108-1 LEFT PASS DOOR DOUBLER



D4108-5 SMALL RIGHT DOOR DOUBLER

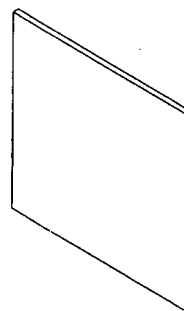


D4108-047 SILL BRACKET ASSEMBLY

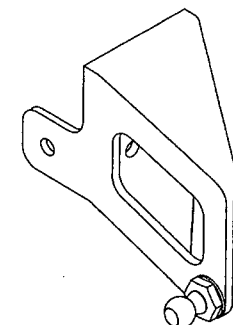


D4108-3 RIGHT PASS DOOR DOUBLER

62302



D4108-11 TEMPLATE



D4108-049 LITTER DOOR FITTING ASSEMBLY

RELEASED
2010-09-23
AM

A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4108	SHEET 1 OF 7
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS & FITTINGS	NTS
DATE	10.07.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -5 : IDENT P/N D4108-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9649.

RELEASE
2010-09-23

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4108	SHEET 4 OF 7
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	DOUBLERS & FITTINGS	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.07.20		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Receiving Report

Date: 10/9/17

Batch No: M115688

Supplier: Magna

Dart P/O: 12546

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection 8 N/A ☐
 Work Order 106424 N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
303D 1"		24	0	0	24	

Initials of receiver (if shipment OK) Level 12 CZ

Production/Admin: 10/9/20
 Date
 Received/Costing CS
 Initial

Location _____

Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID PO12546 Receipt Dates from 9/20/2010 to 9/20/2010 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name		VC-MAG002	Magna Stainless								
PO12546	2		M304S16GA sf		9/15/2010	9/20/2010	160.0000	\$5.25	0.0000	0	\$840.00
CAD	No		304/316 Sheet .063 sf		160.0000	DESJ02		\$840.00	0.0000	0	
			115688								
	3		M6061T6A1.000W.1 f 25		9/15/2010	9/20/2010	40.0000	\$0.60	0.0000	0	\$24.00
	No		6061T6 ANGLE 1.00 f x 1.00 x .125W		40.0000	DESJ02		\$24.00	0.0000	0	
			115688								
									Total Received Quantity:		200.0000
									Total Qty to Inspect (PO U/M):		0.0000
									Total Reject Quantity:		0.0000
									Total Receipt Value:		\$864.00
									Total Balance Due Quantity:		0.0000



Magna Stainless

5775 Kieran St. Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



PACKING LIST

Page 1 of 1

I032442

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7



*****STOCK***

SPECIAL INSTRUCTIONS

Contact: C. LAVOIE

Ship Terms: PREPAID

MTR:Y

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		DAVE MC VETY	(613) 632-5200	(613) 632-1053	12546	
Sales Order	Terms	Ship Via		Date Ordered	Date Required	Date Shipped
W035566	NET 30 DAYS	NIR:R-557065-1		09/16/10	09/17/10	09/17/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
2		PC	ALUMINUM ANGLES AAN 6061 T6 1" x 1" x 1/8" x R/L 20' 12 LB / 2 PC	L042208	2BM307	2
5		PC	STAINLESS SHEET SSH 304 2B 16ga x 48" x 96" 420 LB / 5 PC	L040896	A0587-3030	5
Bundles: 1		Skids: 1		Approx Weight:		432 LB

Received by:

Date:

Signature:



INSPECTION CERTIFICATE

CERTIFICATE NO.: SK-99040

CUSTOMER: MAGNA STAINLESS INC.(DIV OF CANADIAN SPECIALTY METALS INC.)

VOICE NO.: SSCAE40302TE9

CREDIT NUMBER: I700625

DESCRIPTION: STAINLESS STEEL SHEETS

JUN 01 2010

P/L NO.	SIZE	PCS	N.W. (KG)	SPEC	HEAT NO.	REFERENCE NO.
59	0.9mm (20ga) X 1219mm (48") X 3048mm (120")	86	2256	304 / 2B	A0639-2010	F8055
60	0.9mm (20ga) X 1219mm (48") X 3048mm (120")	86	2259	304 / 2B	A0639-2010	F8055
61	1.2mm (18ga) X 1219mm (48") X 2438mm (96")	87	2428	304 / 2B	B7113-1020	F8209
62	1.2mm (18ga) X 1219mm (48") X 3048mm (120")	64	2232	304 / 2B	B7113-1020	F8209
63	1.2mm (18ga) X 914mm (36") X 3048mm (120")	51	1342	304 / 2B	YU256274	93S51062B
64	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	70	2433	304 / 2B	A0587-3030	F8139
65	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	70	2434	304 / 2B	A0587-3030	F8139
66	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	70	2435	304 / 2B	A0587-3030	F8139
67	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	58	2013	304 / 2B	A0587-3030	F8139
68	1.5mm (16ga) X 1219mm (48") X 3048mm (120")	51	2218	304 / 2B	A0587-3030	F8139

Chemical Composition

P/L NO.	C	Si	Mn	P	S	Ni	N	Cr	Mo	Y.S.(0.2%) N/mm2	T.S. N/mm2	Elongation %	HRB
59	0.048	0.526	1.139	0.031	0.006	8.136	0.0590	18.0510	-	283	640	54.3	80.6
60	0.048	0.526	1.139	0.031	0.006	8.136	0.0590	18.0510	-	283	640	54.3	80.6
61	0.047	0.447	1.207	0.032	0.004	8.017	0.0500	18.1500	-	295	629	54.7	82.0
62	0.047	0.447	1.207	0.032	0.004	8.017	0.0500	18.1500	-	295	629	54.7	82.0
63	0.043	0.520	1.110	0.030	0.001	8.100	0.0250	18.1300	-	306	685	51.0	87
64	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
65	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
66	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
67	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
68	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7

Mechanical Test

Remark: 1. We hereby certify that the products described herein have been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.

2. As per ASTM A240/480 standard.

3. The material described above has been detected with free irradiation.

Q.C. MANAGER

Jai



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO12546**

Purchase Order Date 9/10/10

PO Print Date 9/10/10

Page Number 1 of 1

Order From :

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

VC-MAG002

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

10127-2607

Net 30

CAD

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
622-9100

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M303R1.000	303 Round Bar 1.00	9/15/10 Yes	24.00 f	Yours ppd	\$6.6667	\$160.00
Special Inst: MATERIAL: 303 SS ROUND BAR NOTE: AISI 304/316 NOT ACCEPTABLE							
2	M304S16GA C21019117	304/316 Sheet .063	9/15/10 Yes	160.00 sf	Yours ppd	\$5.2500	\$840.00
Special Inst: MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240							
3	M6061T6A1.000W.125 C21019117	6061T6 ANGLE 1.00 x 1.00 x .125W	9/15/10 Yes	40.00 f	Yours ppd	\$0.6000	\$24.00
Special Inst: MATERIAL: 6061-T6 OR T6510/T6511 ALUMINUM ANGLE AS PER AMS-QQ-A-200/8							
<div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div> <div>POSITIVE RECALL EFFECTIVE 10-9-17 AUTH C21019117 RELEASED 10-9-24 DATE 10-9-24</div> <div>PO Total: \$1,024.00</div>							

Change Nbr: 1

Change Date: 9/10/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Work Order Summary

October 18, 2010 8:05:48 AM

Page 1 of 2

Criteria : Work Order ID: 62303 Item ID: D4108-5 Product Family SMALL FAB
 Work Order Start Dates 9/27/10 to 9/27/10 11:59:59 PM Work Order Required Dates 10/04/10 to 10/04/10
 11:59:59 PM

All References

Work Order Status Released

Work Order ID 62303 Required Qty 3.0000 Status Code Released
 Item ID D4108-5 Accepted Qty 0.0000 Scrap Qty 0.0000
 Item Name Small Right Door Doubler
 Current Acct Value \$0.174 Sales Order ID

Start Date	9/27/10	Required Date	10/04/10	Completed Date	
Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
Direct Costs	Total	Each	Each	Each	Each
Material	\$1.048	\$0.000	\$0.174	\$0.174	100.00%
Labor	\$20.312	\$0.000	\$0.000	\$0.000	0.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$41.843	\$0.000	\$0.000	\$0.000	0.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$63.203	\$0.000	\$0.174	\$0.174	

Item ID/ Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M304S16GA	0.0996				
304/316 Sheet .063			9/27/10	0.2000	\$1.048
Total Matl Amts:					\$1.048

Work Center Small Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUC01												
	10/12/10											
130			0.00	0.00	0.47	0.16	3.00	\$0.000	\$3.005	\$6.190	\$0.000	\$9.19
BOUC02												
	10/12/10											
130			0.00	0.00	0.14	0.14	1.00	\$0.000	\$2.750	\$5.665	\$0.000	\$8.41
Total:			0.00	0.00	0.61	0.30	4.00	\$0.000	\$5.755	\$11.855	\$0.000	\$17.61

Work Center Waterjet

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BLEC01												
	9/27/10											
100			0.00	0.00	0.29	0.29	1.00	\$0.000	\$5.597	\$11.530	\$0.000	\$17.12
BOUC01												

October 18, 2010 8:05:48 AM

Work Order Summary

Page 1 of 2

9/28/10											
100	0.00	0.00	0.46	0.46	1.00	\$0.000	\$8.960	\$18.458	\$0.000	\$27.41	
Total:	0.00	0.00	0.75	0.75	2.00	\$0.000	\$14.557	\$29.988	\$0.000	\$44.54	